

Date: Monday, 2/27/2006 4:18:21 PM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SADDLE, OUTBOARD, RH, 206
Job Number	25980		
Estimate Number	10523		
P.O. Number	N/A	Part Number	D26652
This Issue	2/27/2006	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2665 REV. B
First Issue	N/A	Project Number	N/A
Previous Run	24848	Drawing Revision	B
Written By	<u>See Comments Below</u>		
Checked & Approved By	P.O. 06.02.28		
Comment	Est: C 00.11.01	Removed P/O for Powder Coat - in house process EC	
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 12.0000 Each(s)	
	7075-T7351 2X6.25X7.875		
	Cut Size 2.0" x 6.25" x 7.88"	Grain Along Long 7.88 Length	R24891
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment:	HAAS CNC VERTICAL MACHINING #1		
	1- Program batch number		
	2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet		
	3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet		
	4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet		
	5- Deburr		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment:	CONVENTIONAL MILLING MACHINE		
	Machine Keyway and inspect per attached dimension sheet		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK	
Comment:	SECOND CHECK		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/07/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:18:21 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 25980

Part Number: D26652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

3A0

06/07/25

(12)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC

06/07/26

(12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SP 06/07/27

(5)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 55483

SP 06/07/27

(5)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/07/28

(10)

Job Completion



SP 06.07.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

25980

Description: 206 Saddle, Outboard, Right side

Part Number:

D2665-2

Inspection Dwg: D2665 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.127	.127	.125		
B	0.100	0.140		.122	.127	.127	.127		
C	0.100	0.140		.119	.123	.124	.122		
D	0.210	0.230		.226	.228	.228	.226		
E	1.245	1.255		1.256	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.127	.126	.126	.126		
O	0.540	0.560		.549	.549	.548	.549		
P	0.490	0.510		.493	.498	.499	.499		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.254	.260	.261	.258		
T	0.100	0.180		.150	.150	.150	.145		
U	0.313	0.318	DT8686	/	/	/	/		
V	1.125	1.145		1.142	1.132	1.131	1.134		
W	1.565	1.585		1.572	1.572	1.571	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD / Ep  
Date: 06/07/27 06/07/24Audited by: J.F  
Date: 06/07/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD

Work Order: 25980

Description: 206 Saddle, Outboard, Right side

Part Number: D2665-2

Inspection Dwg: D2665 Rev. B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.122	.126	.125	.126		
B	0.100	0.140		.123	.126	.128	.126		
C	0.100	0.140		.119	.120	.124	.122		
D	0.210	0.230		.223	.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500					
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.123	.124	.123	.124		
O	0.540	0.560		.549	.549	.549	.549		
P	0.490	0.510		.496	.498	.496	.499		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.254	.255	.257	.257		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.134	1.132	1.133		
W	1.565	1.585		1.573	1.574	1.572	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: SD / EP  
 Date: 06.06.21 / 06/07/21

Audited by: J.F.  
 Date: 06/07/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

DART AEROSPACE LTD	Work Order:	25980
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.125	.126	.127		
B	0.100	0.140		.127	.127	.129	.129		
C	0.100	0.140		.123	.122	.123	.122		
D	0.210	0.230		.224	.224	.224	.223		
E	1.245	1.255		1.258	1.250	1.256	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		5.998	5.998	5.998	5.998		
H	0.510	0.515		0.515	0.515	0.515	0.515		
I	1.674	1.684		1.672	1.679	1.679	1.679		
J	2.495	2.505		2.502	2.500	2.501	2.501		
K	0.257	0.262	DT8683		—	—	—		
L	0.312	0.317	DT8686		—	—	—		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		.124	.124	.123	.123		
O	0.540	0.560		.549	.548	.548	.548		
P	0.490	0.510		.499	.497	.499	.495		
Q	3.609	3.619		3.613	3.613	3.613	3.613		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.257	.257	.256	.256		
T	0.100	0.180		.145	.145	.145	.145		
U	0.313	0.318	DT8686		—	—	—		
V	1.125	1.145		1.133	1.133	1.133	1.132		
W	1.565	1.585		1.573	1.573	1.575	1.573		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

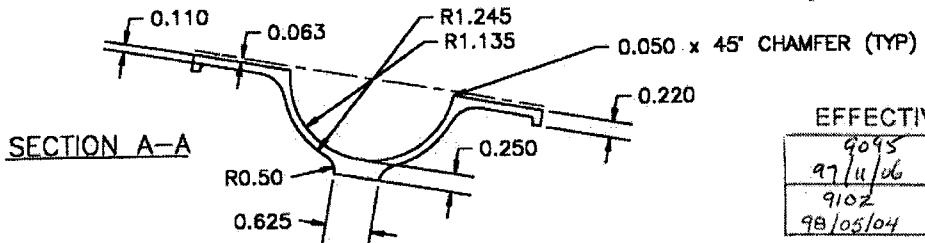
Measured by:	S A / EP	Audited by:	J.F. OS
Date:	06.06.28 / 06/07/24	Date:	06/07/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

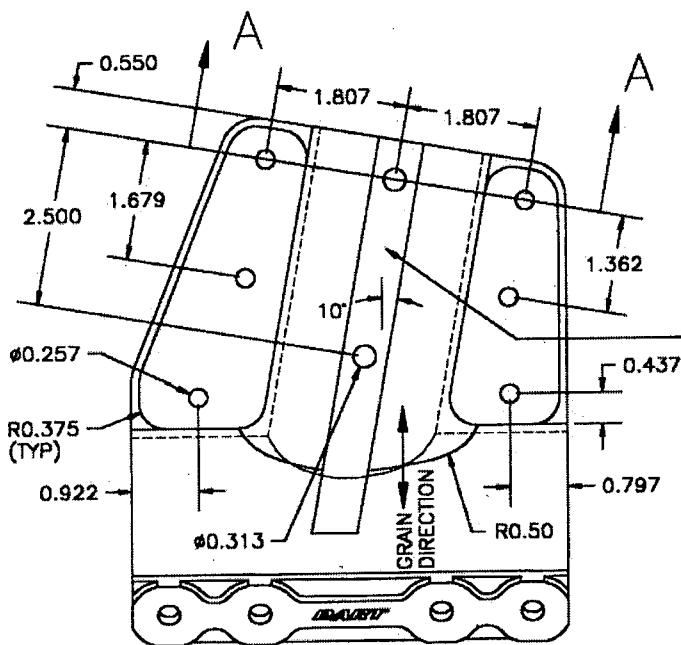
**DART**

DA COPY IS  
ISSUED

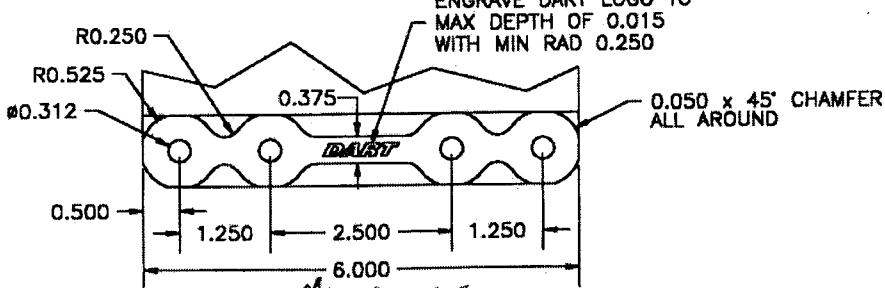
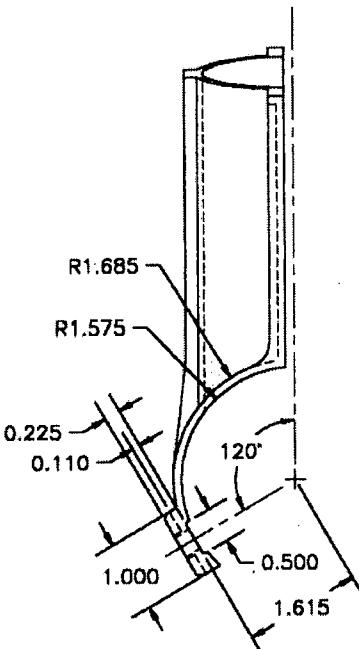
DESIGN <i>0108</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>0108</i>	APPROVED <i>AS</i>	DRAWING NO. D2665	REV. B SHEET 1 OF 1
DATE 97.07.11		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 2:5
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	



EFFECTIVE	DEOs
9095 97/11/06 DS	9122 98/12/14
9102 98/05/04 DS	



ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



MATERIAL: 7075-T651 OR 7075-T7351 (QQ-A-250/12)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2665-1 SHOWN (D2665-2 IS OPPOSITE)

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
97/07/16 DS  
ECN 008

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *25980*

